

Work Order ID 63248

Tuesday, October 26, 2010 10:37:31 AM

Page 1

Item ID: D3508-13

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearplate

Start Date: 10/26/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 11/2/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan: mfDate: 10-10-26

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3508

Rev C

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3508 ☐ Dwg Rev: C ☐ Prog Rev: C ☐ 2-
Deburr if necessary

364 . 040

B10-10-27

(14)

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B10-10-27

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

50/10/27

(14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 3

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Accept

Setup Start

Revision ID:

Stop

Item Name: Wearplate

Start Date: 10/26/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 11/2/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00

8/10/10/29



QC

Memo

0.00

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00

8/10/10/29



QC

Memo

0.00

Quality Control

(+14)

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M 112588



Powdercoat

Memo

0.00

Powder Coating

START TIME:

2:45

OVEN TEMPERATURE:

320

FINISH TIME:

3:15

14

10-11-3

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

Work Order ID 63248

Tuesday, October 26, 2010 10:37:31 AM

Page 4

Item ID: D3508-13

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearplate

Start Date: 10/26/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 11/2/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

QC3- Inspect Part Finish

0.00

10/11/03

14

0



QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location: *FP-10* 0.00

0.00

14

10-11-3



Packaging

Memo

0.00

Packaging

210

QC21- Final Inspection - Work Order Release 0.00

0.00

10/11/04



QC

Memo

0.00

Quality Control

MF

10-11-3

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NOTE: Date & initial all entries

Picklist Print

Tuesday, October 26, 2010 10:37:31 AM

Page 1

Work Order ID: 63248



Parent Item: D3508-13



Parent Item Name: Wearplate


Start Date: 10/26/2010

Required Date: 11/2/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07.06.12 EC
IPP Rev:B Rev C dwg 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 		Purchased	No			100	sf	176.7000	0.172	1.086316	2.5		
304/316 .040 Sheet													



B10-10-27

Location

Loc Qty

Loc Code

MAT

172.7

115762

12.7

115953

160

MAT20

4

113062

1.398

115440

2.602

115762

14

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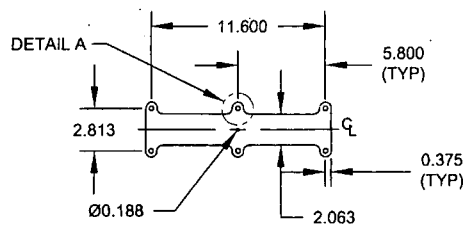
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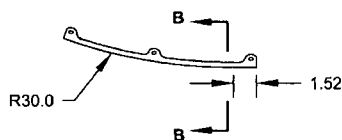
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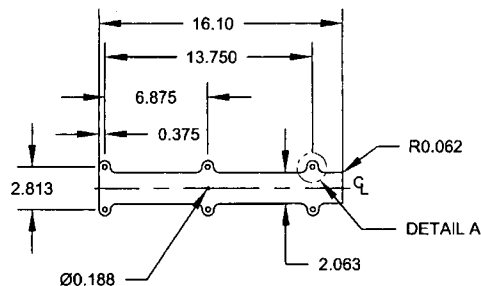
NOTE: Date & initial all entries



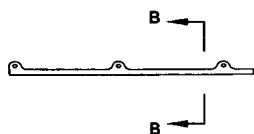
D3508-1 FLAT PATTERN



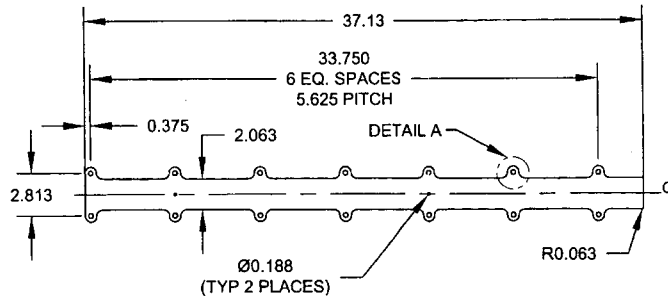
D3508-1 BENDING DETAIL
(MAKE FROM D3508-1F)



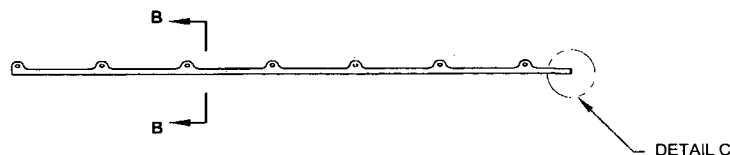
D3508-7F FLAT PATTERN



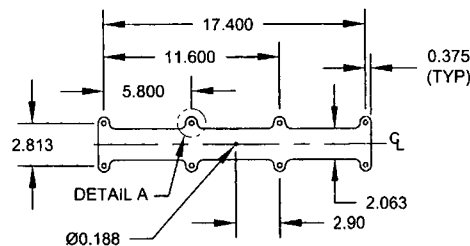
D3508-7F BENDING DETAIL
(MAKE FROM D3508-7F)



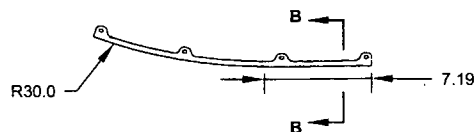
D3508-3 FLAT PATTERN



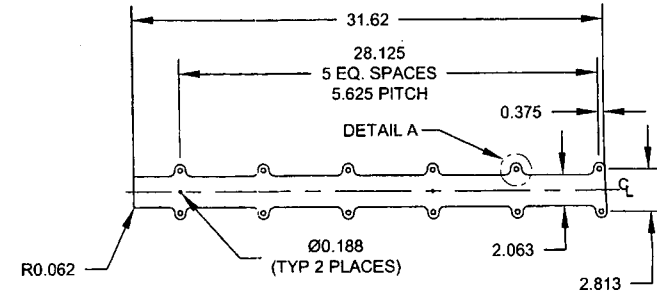
D3508-3 BENDING DETAIL
(MAKE FROM D3508-3F)



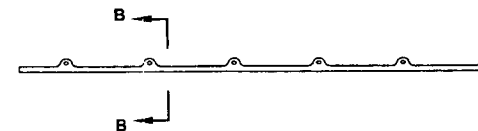
D3508-9F FLAT PATTERN



D3508-9F BENDING DETAIL
(MAKE FROM D3508-9F)



D3508-5 FLAT PATTERN









D3508-5 BENDING DETAIL
(MAKE FROM D3508-5F)

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF. DART MATERIAL SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.015
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: D3508-1 - 0.47 lbs, D3508-3 - 0.95 lbs, D3508-5 - 0.77 lbs,
D3508-7 - 0.39 lbs, D3508-9 - 0.45 lbs, D3508-11 - 0.64 lbs
D3508-13 - 0.25 lbs

RELEASED
07-11-16

C	ADD -9/-11/-13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT	PH	07.04.20
B	CHANGE STAINLESS STEEL, WIDEN	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3508	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	1:
DATE	07.04.20	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

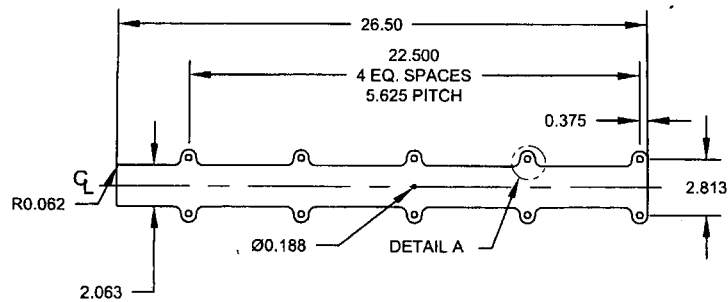
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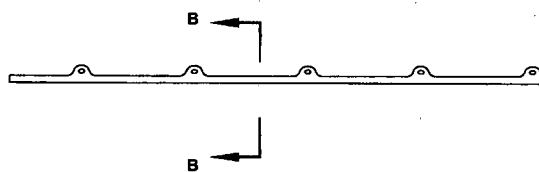
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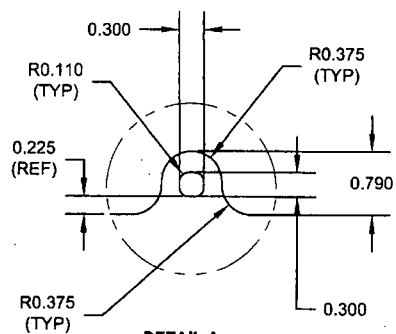
NOTE: Date & initial all entries



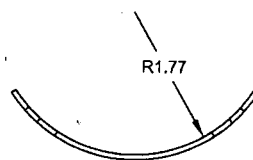
D3508-11F FLAT PATTERN



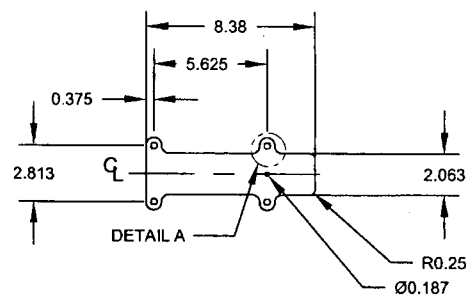
D3508-11 BENDING DETAIL
(MAKE FROM D3508-11F)



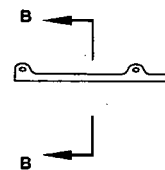
DETAIL A
(SCALE 2:3)



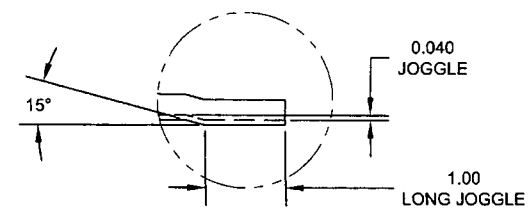
SECTION B-B
(SCALE 2:3)



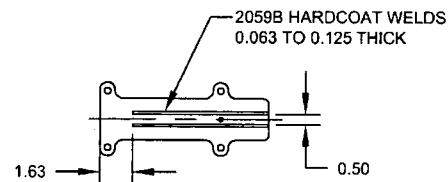
D3508-13F FLAT PATTERN



D3508-13 BENDING DETAIL
(MAKE FROM D3508-13F)



DETAIL C
(SCALE 1:2)



D3508-13 WELDING DETAIL

#63248

RELEASED
07-11-16

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3508	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	1:6
DATE	07.04.20	<small>COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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